

Ship April 13

Work Order ID 81185

81185

Page 1

Item ID: D3914-041

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012 Start Qty: 2.00

Required Date: 19/03/2012 Req'd Qty: 2.00

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling:

QC: Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3914

B

D4020

A

100

Weld per dwg A/R S.S. rod Batch: 118366 0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

12.04.05 14

12.04.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81185

March-12-12 8:40:46 AM

81185

Page 2

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 09/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 19/03/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Quality Control

Memo

0.00

Scrublog

130 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

130

Powdercoat

Powder Coating

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: *7:50*

Oven Temperature: *3200F*

Finish Time: *8:20*

140 Wing Walk as per dwg QSI005 4.4 Batch *120802* 0.00

140

HandFinish

Hand Finishing

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

IX of m-l 12/04/10

1 BL 12-4-10

M 117338

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	Sizbuldo			(K)			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>D4030-041</u> Memo	0.00 0.00	81412					1 BL 12-4-10.	
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/4/12 ME 12-04-11

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

March-12-12 8:40:51 AM

Page 1

Work Order ID: 81185

81185

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	35.0000	2	4			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2581

Mounting Bracket

**

DL 12/04/03

Location

Loc Qty

Loc Code

WA005

35

69739

1

70766

2

77045

3

77523

29

B81253 → (2)

D3914-1		Manufactured	No			100	Each	0.0000	2	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3914-1

Rib

**

DL 12/04/03

Location

Loc Qty

Loc Code

WA

2

WA006

-2

B81407 → (2)

D3914-7		Manufactured	No			100	Each	2.0000	2	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3914-7

Rib

**

DL 12/04/03

Location

Loc Qty

Loc Code

WA006

2

80164

2

B81453 → (2)

D4016-3		Manufactured	No			100	Each	18.0000	3	6			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4016-3

Hinge Half, Lid

**

DL 12/04/03

Location

Loc Qty

Loc Code

WA005

18

78495

18

B81389 → (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-12-12 8:40:51 AM

Page 2

Work Order ID: 81185

81185

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

D4018-5
Rib
D4018-5

Manufactured No

100 Each 7.0000

9
** 18

B 81448 → ①
DL/12/04/03

Location

Loc Qty

Loc Code

WA005

7

80597

7

D4020-5
Mesh (350 Basket Long, Lid)
D4020-5

Manufactured No

100 Each 1.0000

13
** 2

Location

Loc Qty

Loc Code

WA

1

78698

1

D4021-3
Data Plate
D4021-3

Manufactured No

100 Each 3.0000

1
** 2

Location

Loc Qty

Loc Code

WA005

3

75460

3

D4035-041
Lid Rib Assembly, Fwd (350 Basket)
D4035-041

Manufactured No

100 Each 3.0000

1
** 2

Location

Loc Qty

Loc Code

WA006

3

74642

3

D4035-043
Lid Rib Assembly, Aft (350 Basket)
D4035-043

Manufactured No

100 Each 1.0000

1
** 2

Location

Loc Qty

Loc Code

WA006

1

76545

1

DL-12/04/03
B 81450 → ①

DL/12/04/03
B 81452 → ②

March-12-12 8:40:51 AM

Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-12-12 8:40:51 AM

Page 3

Work Order ID: 81185

81185

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

D2728-3

Manufactured No

140

Each

0.0000

1

2

D2728-3

Dart Logo label

15050 .

**

1

BL 124-10.

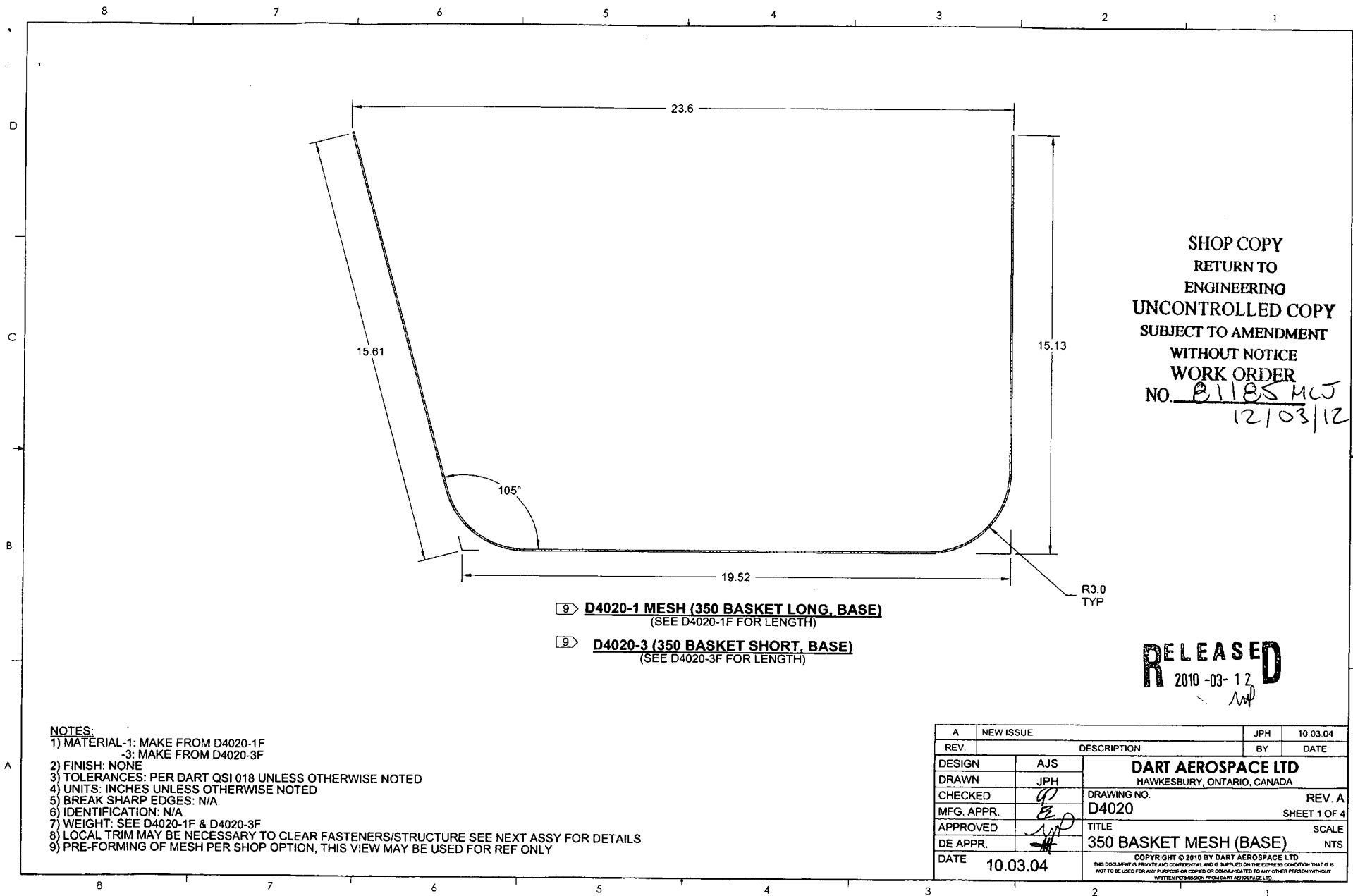
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



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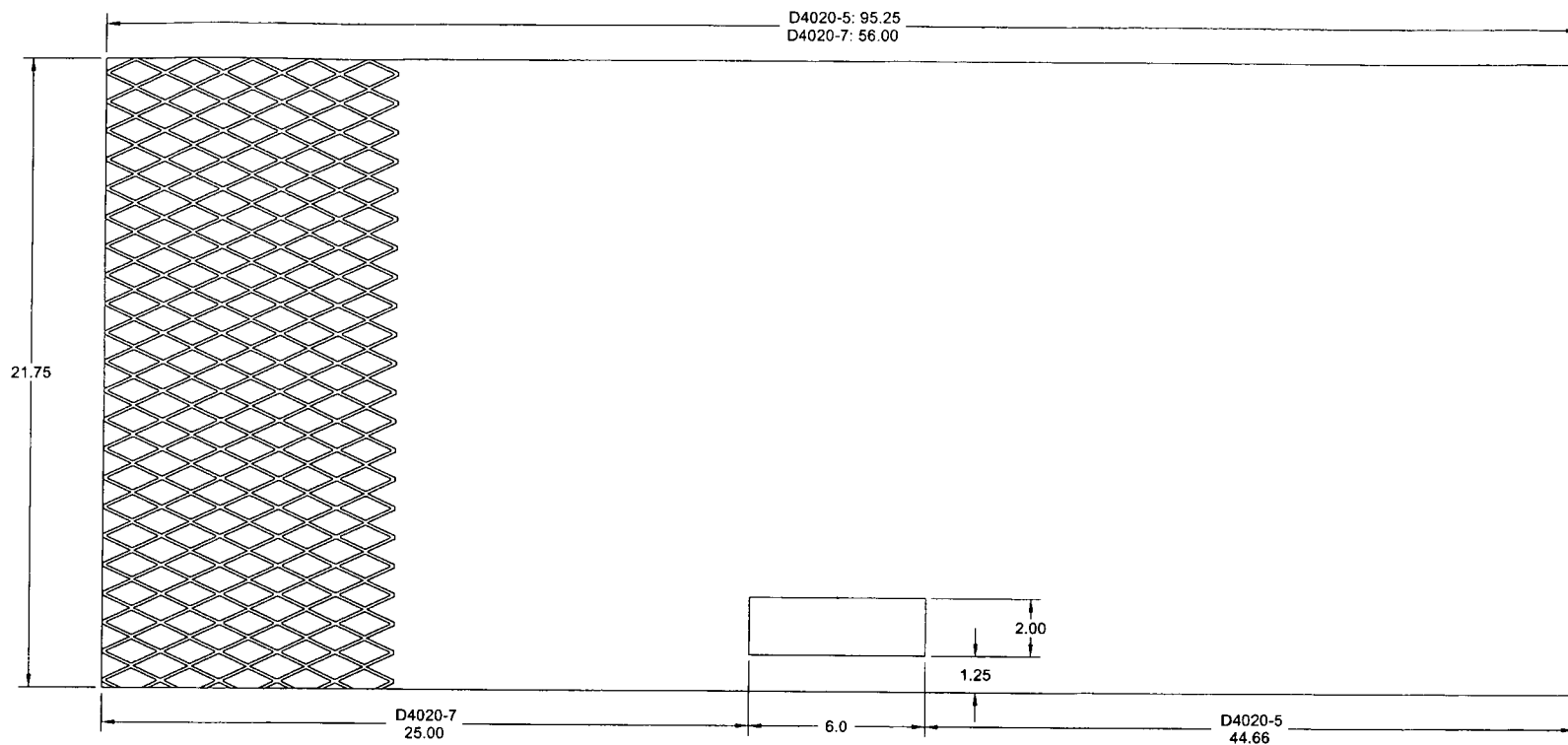
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NOTE: Date & initial all entries

81185



9 **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-12
ND

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a diamond mesh structure. The drawing includes the following dimensions and callouts:

- Overall width: 24.34
- Overall height: 15.50
- Top left corner detail: 0.40 (vertical), 2.88 (horizontal), 17.31 (horizontal), and R1.44 REF (radius).
- Bottom left corner detail: 2.00 (vertical), 5.64 (vertical), 0.38 (horizontal), and 75° (angle).
- Bottom right corner detail: 20.18 (horizontal) and R3.38 2 PL (radius).
- Callouts: Three callouts labeled '8' point to specific features on the mesh.

RELEASED
2010-03-12
mp

9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D4020 TITLE 350 BASKET MESH (BASE) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND RELEASED UNDER THE COPYRIGHT OF DART AEROSPACE LTD THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. A
DRAWN	JPH		SHEET 3 OF 3
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

Dart Aerospace Ltd

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Dart Aerospace Ltd

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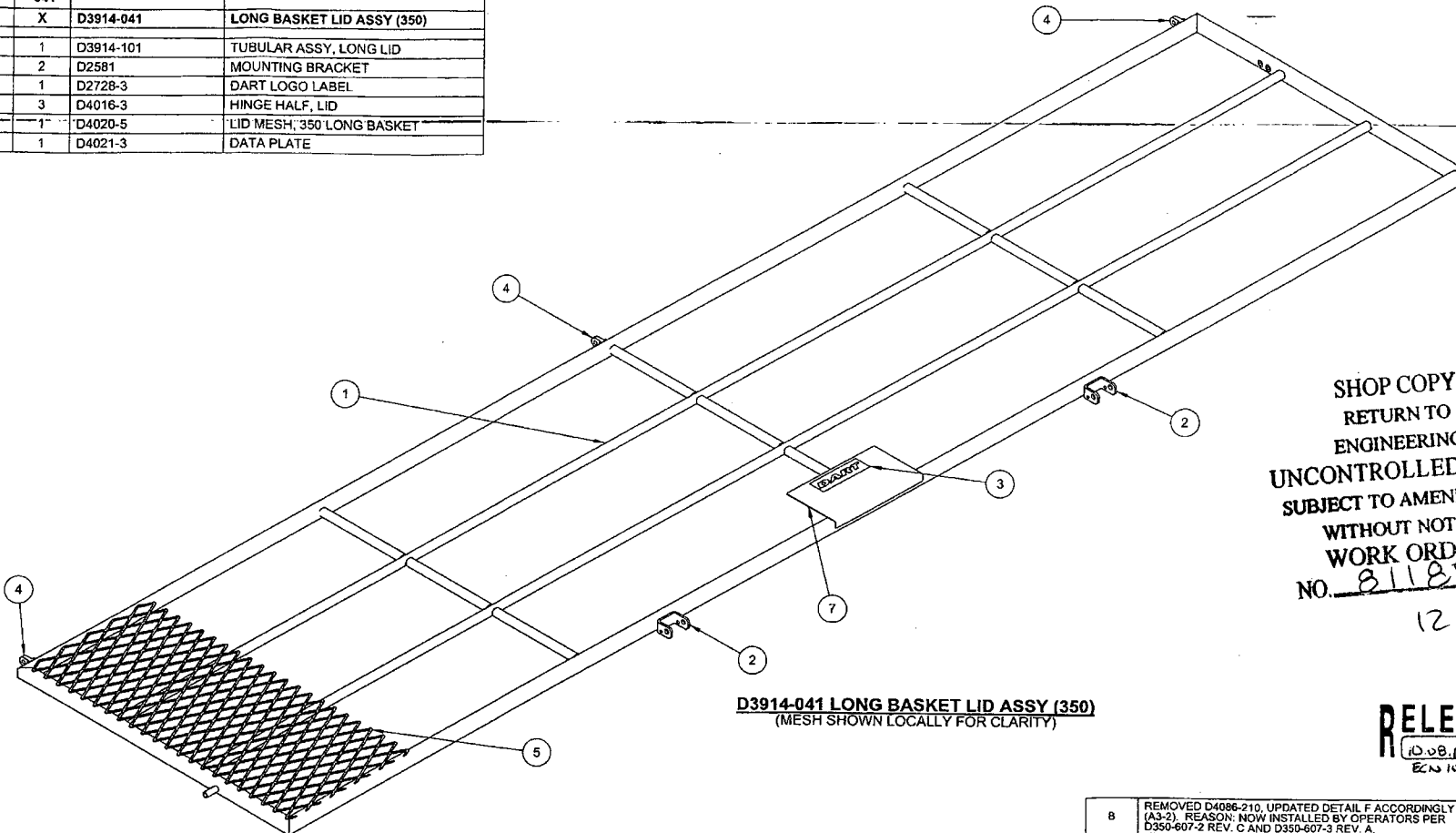
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350' LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81185 MCT
12/03/12

RELEASED
10.08.17 CP
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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NOTE: Date & initial all entries

D4016-3
HINGE HALF, LID
REF

B8-2

D4016-3
HINGE HALF, LID
3 PL

D3914-101
TUBULAR ASSY

A5-2

4 PL

A1-2

D2581
MOUNTING BRACKET
2 PL

81185

RELEASED
10-08-12 up

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

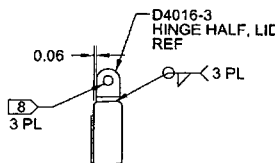
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4020-5
MESH

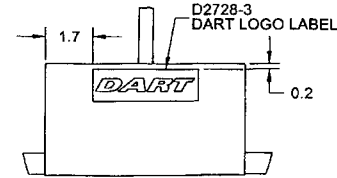
DETAIL B D8-2



DETAIL C C3-2



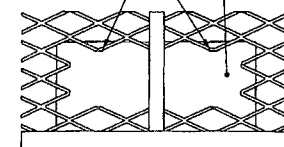
DETAIL D D1-2



DETAIL F C4-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4021-3
DATA PLATE
REF



VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 2 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350)	
DATE	10.08.05	NTS	
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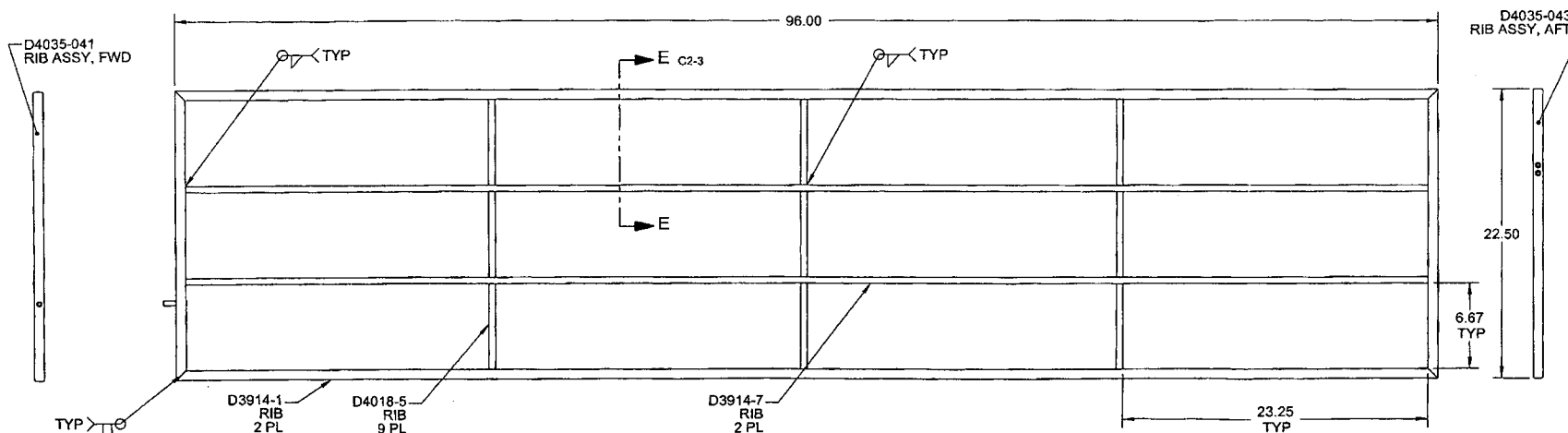
NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

81185



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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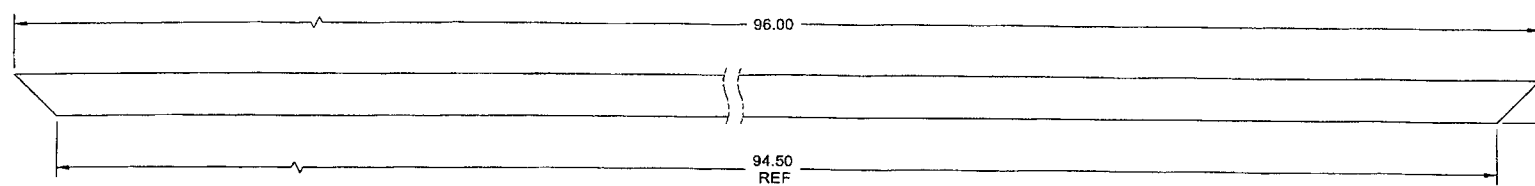
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

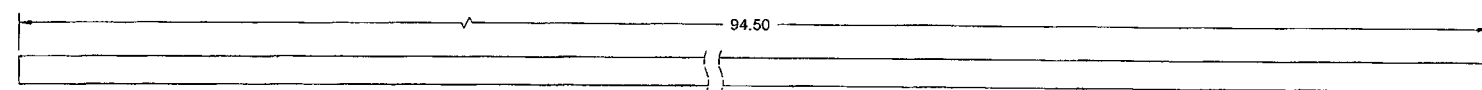
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3914-1 RIB

81185



D3914-7 RIB

NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 QP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

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